

Date: Wednesday, 2/15/2006 1:25:13 PM  
User: Linda Lacelle

## Process Sheet

|   |  |
|---|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services | <b>Drawing Name</b> : SPACER BUSHING                       |
| <b>Job Number</b> : 25823                             |  |
| <b>Estimate Number</b> : 10826                        |  |
| <b>P.O. Number</b> : N/A                              | <b>Part Number</b> : D23273                                |
| <b>This Issue</b> : 2/15/2006 <b>S.O. No.</b> : N/A   | <b>Drawing Number</b> : D2327 REV C                        |
| <b>Prsht Rev.</b> : NC                                | <b>Project Number</b> : N/A                                |
| <b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS | <b>Drawing Revision</b> : C                                |
| <b>Previous Run</b> : 24874                           | <b>Material</b> : N/A                                      |
| <b>Written By</b> : <u>SEE COMMENT BELOW</u>          | <b>Due Date</b> : 2/28/2006 <b>Qty:</b> 50 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>[Signature]</u> |  |
| <b>Comment</b> : Est. F 05.11.02 Removed 303 SS KJ/EC |  |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |           |                      |
|-----|-----------|----------------------|
| 1.0 | M303R0375 | 303 Round Bar 0.375" |
|-----|-----------|----------------------|



**Comment:** Qty.: 0.1641 f(s)/Unit Total : 8.2058 f(s)

Inventory

Material: AISI 303 Round Bar Ø0.375"

(M304R0.375)

Batch: M100255

M8

06/03/23

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|

**Comment:** HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327

Deburr

M8

06/03/23

50

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE M8

06/03/23

50

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK

M8

06/03/24

50

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: W53

C 06/03/27

50

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/28

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 1:25:13 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 25823

Part Number: D23273

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

Handwritten: D06/03/28 (50)

Job Completion



Handwritten: 06.03.28

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

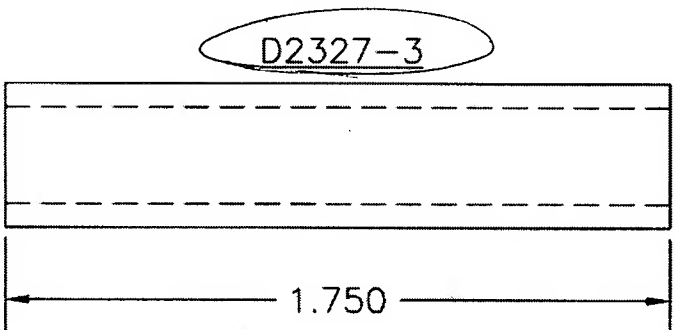
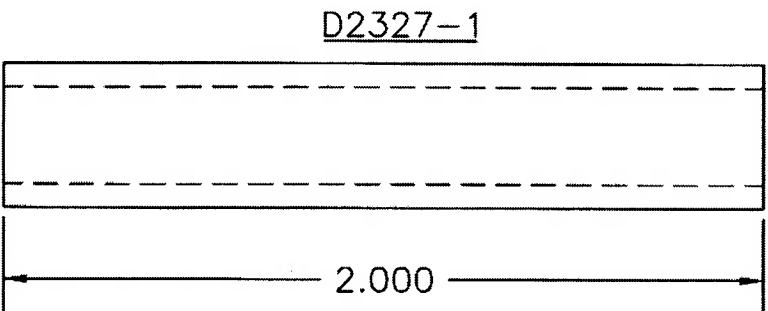
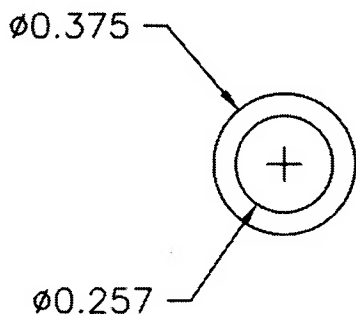
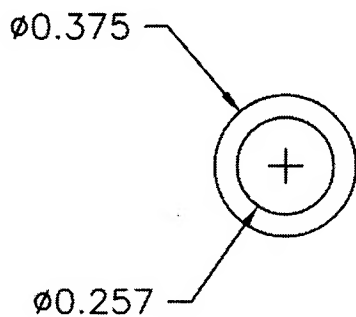
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART**

| DESIGN   |             | DRAWN BY          |             | DART AEROSPACE LTD          |              |
|----------|-------------|-------------------|-------------|-----------------------------|--------------|
| BW       |             | [Signature]       |             | HAWKESBURY, ONTARIO, CANADA |              |
| CHECKED  | [Signature] | APPROVED          | [Signature] | DRAWING NO.                 | REV. C       |
| DATE     |             | TITLE             |             | D2327                       | SHEET 1 OF 1 |
| 03.05.13 |             | SPACER BUSHING    |             |                             | SCALE        |
|          |             |                   |             |                             | 2:1          |
| A        | 94.12.17    | NEW ISSUE         |             |                             |              |
| B        | 95.12.06    | LENGTH CHANGE     |             |                             |              |
| C        | 03.05.13    | 303 SS SPEC ADDED |             |                             |              |

RELEASED  
03.05.21

**NOTE:**

- 1) MATERIAL:  $\emptyset$ 0.375 AISI 303 ROUND BAR (REF DART SPEC. M303R0.375) OR  $\emptyset$ 0.375 AISI 304/316 SS 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article      ☐ Prototype

|                 |                 |                     |
|-----------------|-----------------|---------------------|
| Measured by: MS | Audited by: J-L | Prototype Approval: |
| Date: 06/03/23  | Date: 06.03.23  | Date:               |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/RF      |          |